Work Order ID 60383

ASAP!!!

Wednesday, July 07, 2010 8:26:45 AM

Item ID: AS350-92-26 **Accept** **Setup Start** **Stop**

Revision ID:

Item Name: BRACE STRUT

Start Date: 7/7/2010 **Start Qty:** 1.00 **Cust Item ID:**

Required Date: 7/12/2010 **Req'd Qty:** 1.00 **Customer:**

Reference: **Run Start** **Stop**

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr AS350-9217 **Revision Nbr** 3									
100	Weld per dwg A/R 4130 rod Batch: M100075	0.00							
Large Fab	**Memo**	0.00							
Large Fab	1- Cut and make a groove for bushing AS350-92-22 strut as per dwg 2- Weld parts on strut as per dwg								
110	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
QC	**Memo**	0.00							
Quality Control									
120	QC5- Inspect part completeness to step on W/O	0.00							
QC	**Memo**	0.00							
Quality Control									

10-07-19 1 ✓

1 BE 10/07/19

5/07/19 ✓

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 Powdercoat Powder Coating	White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel M114841	0.00							
	Memo POWDER COAT: Start Time: 1:00 400° Oven Temperature: Finish Time: 1:30	0.00				1		BL 10-7-19	
140 QC Quality Control	QC3- Inspect Part Finish	0.00	N	10/07/19		1	0		
	Memo	0.00							
150 Packaging Packaging	Identify as per dwg & Stock Location: 272	0.00							
	Memo	0.00				10-7-19			SL 10

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

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Run Start

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Stop**

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

H. 10.07.19 Conformity Only to Dwg.

mp

10-7-19

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Picklist Print

Wednesday, July 07, 2010 8:26:44 AM

Work Order ID: 60383

Parent Item: AS350-92-26

Parent Item Name: BRACE STRUT

Start Date: 7/7/2010 **Required Date:** 7/12/2010

Start Qty: 1.00 **Required Qty:** 1.00

Comments: IPP Rev:A New Issue 05-11-21 JLM

Component Item ID / Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AS350-92-12		Manufactured	No			100	Each	333.0000	2	2			
Bushing													
				Location		**Loc Qty**		**Loc Code**					
				WA		333							
					17679	333				2			
AS350-92-18		Manufactured	No			100	Each	55.0000	1	1			
Strap													
				Location		**Loc Qty**		**Loc Code**					
				WA		55				1			
					17679	55							
AS350-92-19		Manufactured	No			100	Each	104.0000	2	2			
Plates													
				Location		**Loc Qty**		**Loc Code**					
				WA		104							
					17679	104				2			
AS350-92-21		Manufactured	No			100	Each	10.0000	1	1			
Bushing													
				Location		**Loc Qty**		**Loc Code**					
				WA		10				1			
					17679	10							
M4130T0.500W.035		Purchased	No			100	f	0.0000	1.3125	1.381579			
4130 SQ tube .500 x .500 x .035w													

~~3513H~~ M17679

Dart Aerospace Ltd

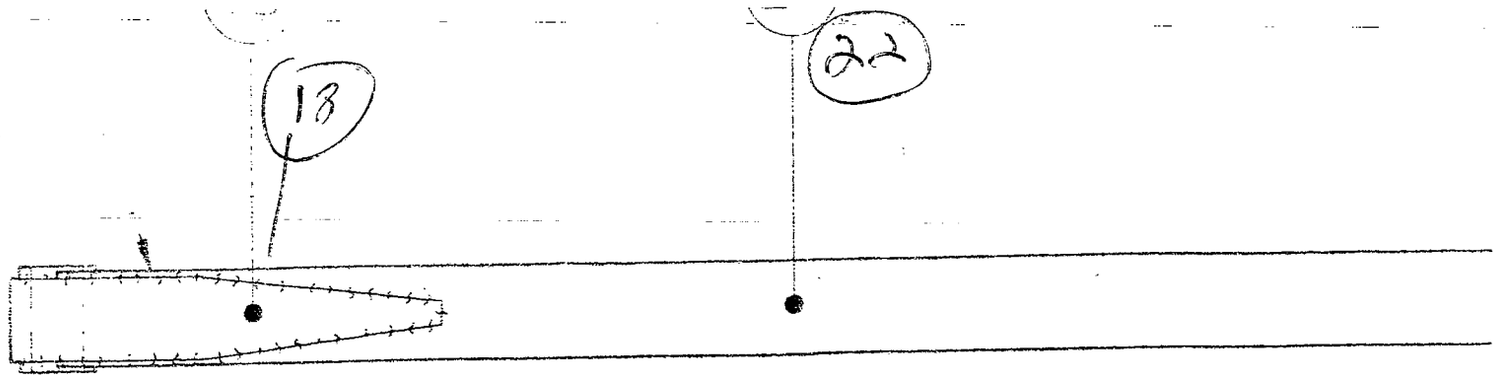
W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

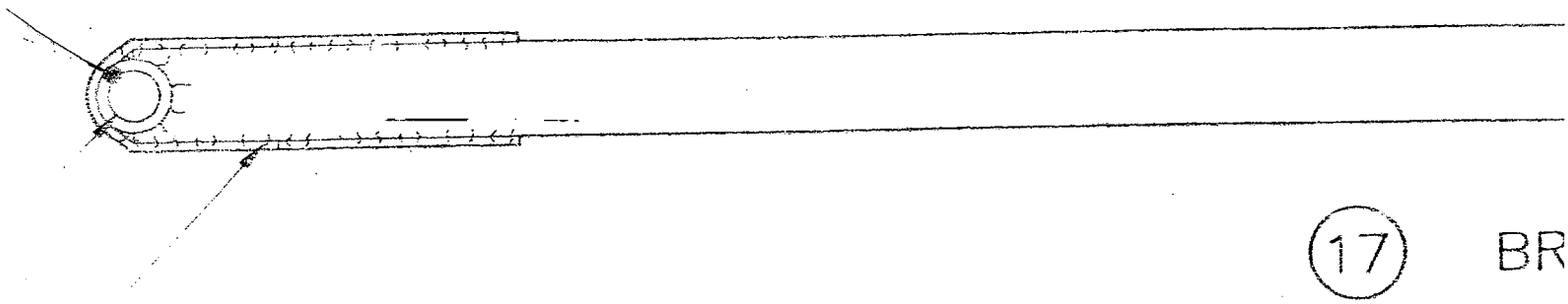
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DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries



E&E 09#

15

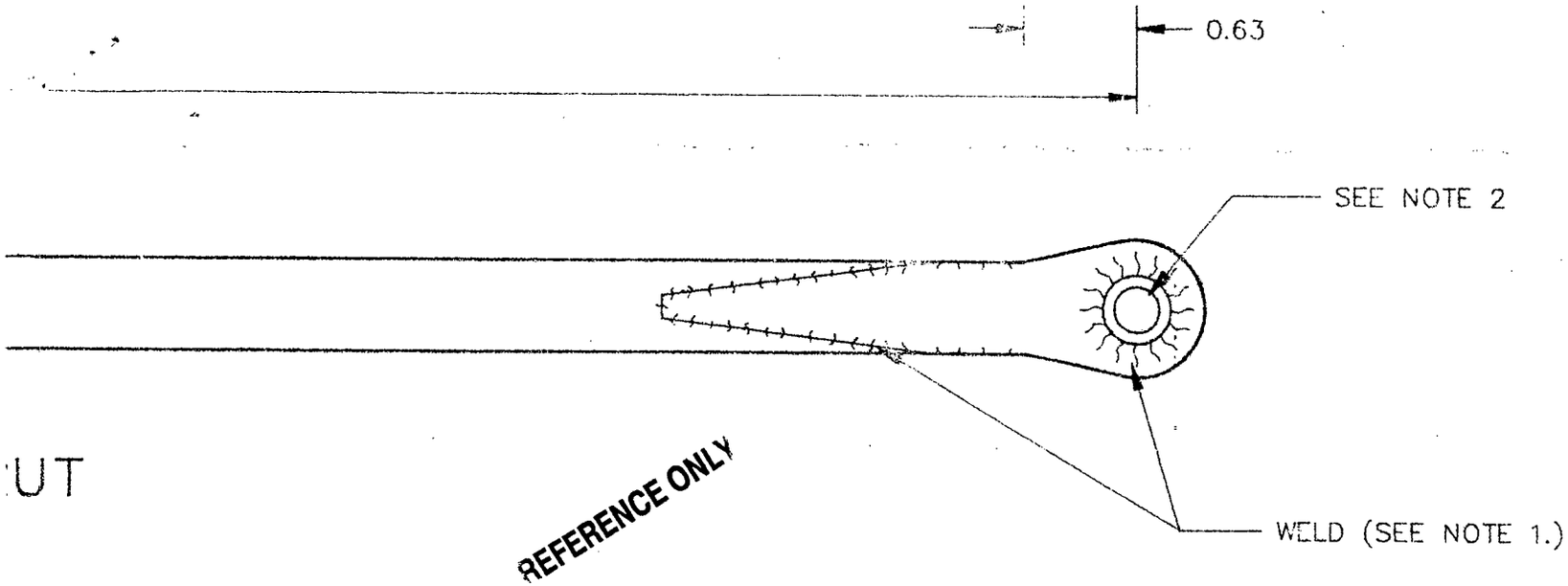


17 BR

Q

BUSHING

NOTES
1. TIG WELD AS PER MIL-E-23765/1B. CLASS MIL-E-
 USE FILLER ROD MIL-R-5632, CLASS 2, TYPE I (A
2. REAM AFTER WELDING TO 0.250/0.251 ?.
3. THOROUGHLY CLEAN AND DEGREASE. PRIME AND
 PER EXISTING AIRCRAFT COLOUR AND REQUIREMEN



:UT

REFERENCE ONLY

NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC.	STOCK SIZE
	22	TUBE	4130 COND. N SQ. TUBE	MIL-T-6736	1/2" SQ. X 0.035 W
	21	BUSHING	4130 COND. N RND. TUBE	MIL-T-6736	3/8" O.D. X 0.065 W X 9/16" LG.
)2-12	12	BUSHING SEE DWG. AS350-9212			
	19	END FITTING PLATE	4130 COND. N	MIL-S-18729	0.063" SHEET
	18	STRAP	4130 COND. N	MIL-S-18729	0.063" SHEET
)2-17	17	BRACE STRUT			

LIST OF MATERIALS

ILESS OTHERWISE SPECIFIED
IMENSIONS ARE IN INCHES
TOLERANCES ON:

:CIMALS	ANGLES
XXX ?0.010	?1/2?
XX ?0.03	
X ?0.1	

DAR/MOT APPROVAL

CANADA
DEPARTMENT OF TRANSPORT
AERONAUTICAL ENGINEERING
DIVISION
30 APR 1993
APPROVED
BY
APPROVAL NO. SH93-1 ISS. 2

APPROVALS	DATE
DRAWN: E. BURGOIN	26 NOV 92
CHECKED:	
STRESS:	
FLIGHT TEST:	

SCALE 1 : 1

AERO DESIGN LTD.

1055 McTAVISH ROAD N.E.
CALGARY, ALBERTA T2E 7G9

EAGLE COPTERS LTD.

823 McTAVISH RD. N. E.
CALGARY, ALBERTA T2E 7G9

AS350 &AS355 CARGO BASKET
BRACE STRUT

SIZE	DWG. NO.	REV.
C	AS350-9217	3